



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-634-141
Job Sheet 174045



Part No: D205-634-141

Job Qty: 1 ea

Part Name: Replacement Skidtube with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/9/18

Job Tracking No:

Due Date: 4/12/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: D205-634 REV.II D2580 REV.H IPP RevA 11.09.14 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER ECN11-684 DD VERF:EC IPP REV:C 13.03.21 AS PER ECN13-544 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/11/18	0.00	0.00	Start Up Skid tubes-1		<i>mbc</i>
110	Skid tubes	1 pcs		4/11/18	0.00	0.65	Skid tubes-2		<i>J. J.</i>
120	CNC Bend Skid tubes	1 pcs		4/11/18	0.52	0.65	CNC Bend Skid tube		<i>J. J.</i>
130	Skid tubes	1 pcs		4/11/18	0.00	0.65	Skid tubes-2		<i>J. J.</i>
140	QC	1 pcs		4/11/18	0.00	0.00	QC5		<i>J. J.</i>
150	Skid tubes	1 pcs		4/11/18	0.00	0.65	Skid tubes-2		<i>J. J.</i>
160	QC	1 pcs		4/11/18	0.00	0.00	QC10		<i>38 DAS</i>
170	QC	1 pcs		4/11/18	0.00	0.00	QC5		<i>38 9-88 38</i>
180	HandFinish	1 pcs		4/11/18	0.00	0.04	HandFinish2		<i>SA 18-04-06</i>
190	Powdercoat	1 pcs		4/11/18	0.00	0.25	Powdercoat1		<i>BE 18-04-09</i>
200	QC	1 pcs		4/11/18	0.00	0.00	QC3		<i>BE 18-04-09</i>
210	HandFinish	1 pcs		4/12/18	0.00	0.83	HandFinish4		<i>BE 18-04-09</i>
220	QC	1 pcs		4/12/18	0.00	0.00	QC5		<i>38</i>
225	DC	1 pcs		4/12/18	0.00	0.00	DC		<i>9-88</i>
230	Packaging	1 pcs		4/12/18	0.00	0.00	Packaging3-1		<i>DAS</i>
240	QC21-FG	1 Ea		4/12/18	0.00	0.00	QC21		<i>21</i>

Part Op 110 - 1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL 3.630" HOLES
Descriptions: USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY)

120 - 1-Bend as per program D2580.C on CNC Bender and Folio FT 16

130 - 1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size.

150 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod 2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR

180 - And realodine tube as per QSI 005

190 - START TIME: *8:50*

210 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 *18/04* 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594 3- Install aft cap as per dwg 4- Wing walk as per dwg Batch# *M138761*

220 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

225 - Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG004

230 - Identify and pack for shipping as per PPPD205-634-141 Location : FG084

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 Ea (1 ea)	90-Start up Operation	5058999
D2576-3	Step (Machining Detail)	1 Ea (1 ea)	150-Skidtubes	5156023
D4202-1	Spacer	24 Ea (24 ea)	150-Skidtubes	5039216
AN3-5A	Bolt	2 Ea (2 ea)	210-HandFinish	5041106
AN4-45A	Bolt	8 Ea (8 ea)	210-HandFinish	5017093
D2570	Bushing	16 Ea (16 ea)	210-HandFinish	5050169
D2594-1	Plug	8 Ea (8 ea)	210-HandFinish	5045769
D2594-3	O-Ring	8 Ea (8 ea)	210-HandFinish	5049975
D2855	Cap	1 Ea (1 ea)	210-HandFinish	5151613
D4406-041	Fwd Wearplate Assembly	1 Ea (1 ea)	210-HandFinish	5055406
D4406-043	Aft Wearplate Assembly	1 Ea (1 ea)	210-HandFinish	5041898
MS21042-4	Nut	8 Ea (8 ea)	210-HandFinish	5038763
NAS1149D0332J	Washer	2 Ea (2 ea)	210-HandFinish	5020606

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2580-1	1	5	0
150-Skidtubes	D2576-3	1	29	0
	D4202-1	24	636	0
210-HandFinish	AN3-5A	2	454	0
	AN4-45A	8	62	0
	D2570	16	703	0
	D2594-1	8	388	0
	D2594-3	8	741	0
	D2855	1	49	0
	D4406-041	1	2	0
	D4406-043	1	2	0
	MS21042-4	8	155	0
	NAS1149D0332J	2	3,596	0

Part Specifications	
Specifications could not be found.	

Plex 3/9/18 12:01 PM Dart.Gagnon.Michelle

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CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S058302



Part: D205 - 634 - 141

Job No: 174045

Serial No/Batch: S058302

Revision: H/I

Inspector:

Date: 04/05/18

002334

ITEM	QTY -041	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2576-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2584-1	PLUG
25	16	16	8	8	D2584-3	O-RING
26	1	1	1	1	D2596	205 WEB
27	1	1	1	1	D2655	AFT CAP
28	1	1			D3584-5	WEARSHOE
29	1	1			D3584-9	WEARSHOE
30	1	1			D3584-11	WEARSHOE
31	1	1			D3584-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4406-041	WEARPLATE ASSEMBLY
34			1		D4406-043	WEARPLATE ASSEMBLY
35				1	D6061-1	FWD WEARPLATE
36				1	D6061-3	AFT WEARPLATE
50	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
51	50	50			AN3C4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-5A	BOLT
54	50	50			NAS1149C0332R	WASHER (AN890C10L)
55	2	2	2	2	NAS1149C0332J	WASHER (AN890JD10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 174045
MAR 09 2018

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 016 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.287 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2655 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

H	SHEET: PL DELETE D3586-1/-5/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048, -047 WEIGHT UPDATED PER DSI 9598	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PART2-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.08.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 8124/ 9183	PH	07.04.06
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	06.06.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	17.06.09		

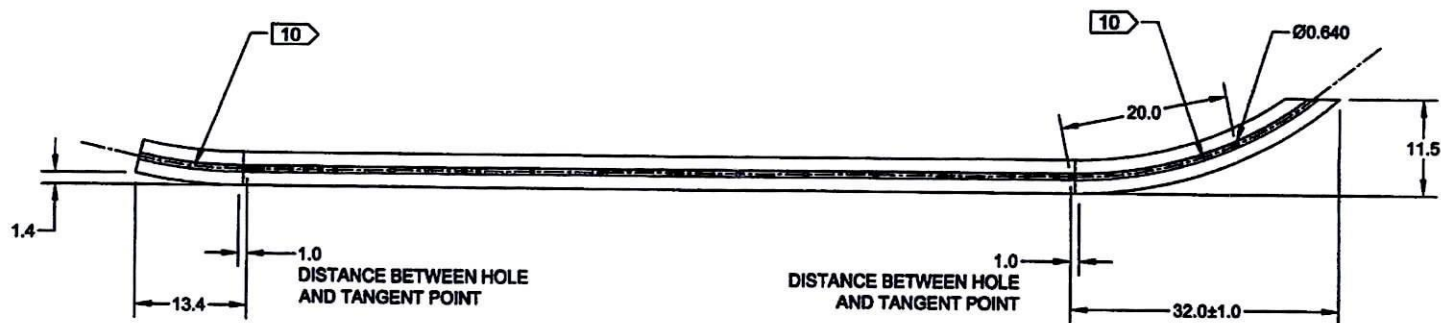
DART AEROSPACE LTD
HANKESSBURY, ONTARIO, CANADA

DRAWING NO.
D2580
TITLE
205 SKIDTUBE ASSEMBLY
REV. H
SHEET 1 OF 9
SCALE
NTS

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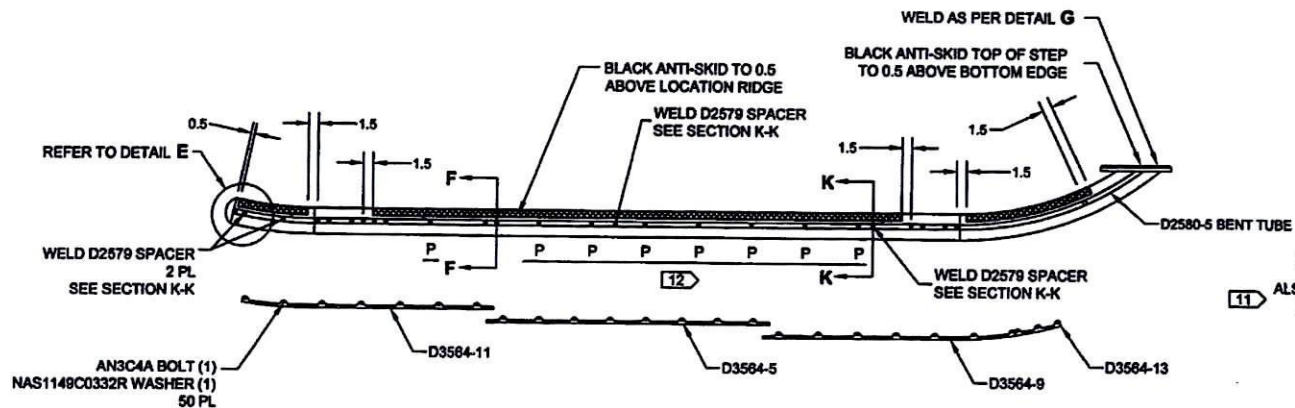
2017 JUL 05
ECN 17-518



D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

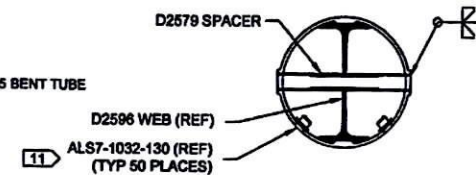
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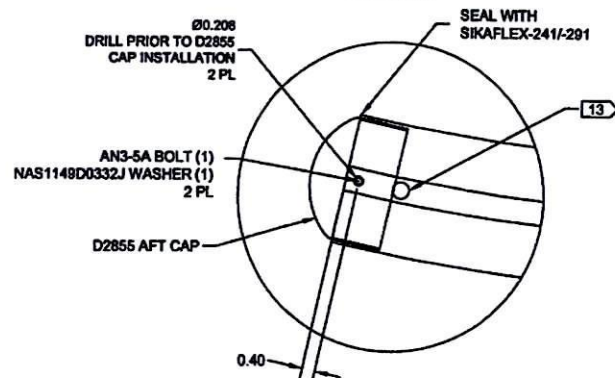
D2580-045 ASSEMBLY DETAIL

**SECTION K-K
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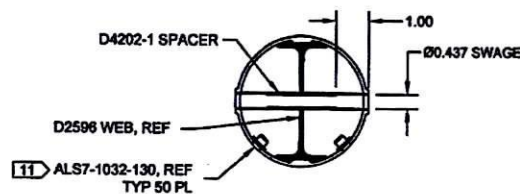


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE

**DETAIL E
SCALE 5X**

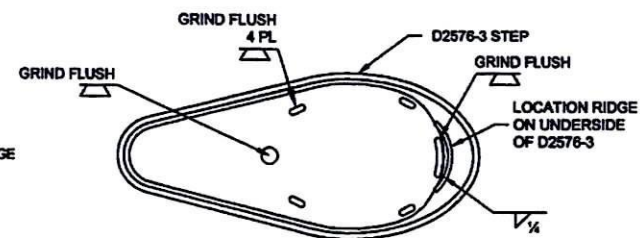


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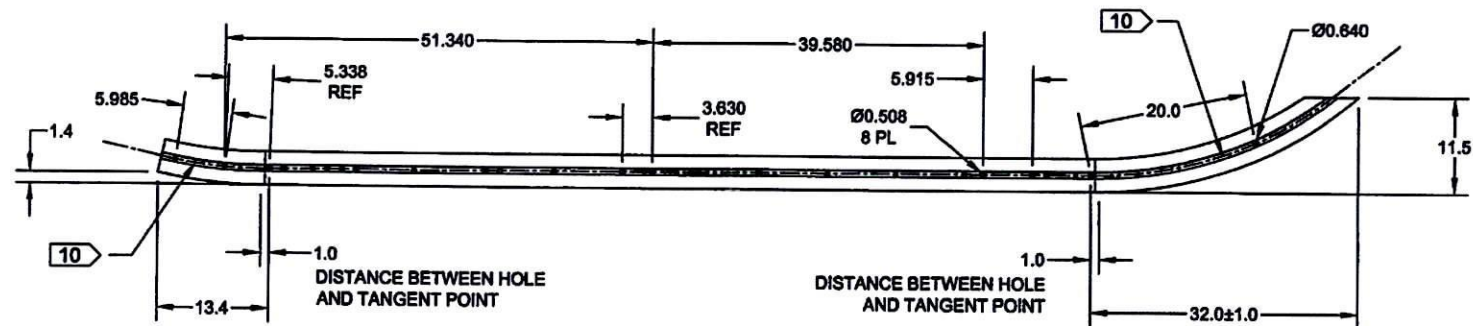
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

**DETAIL G
SCALE 5X**



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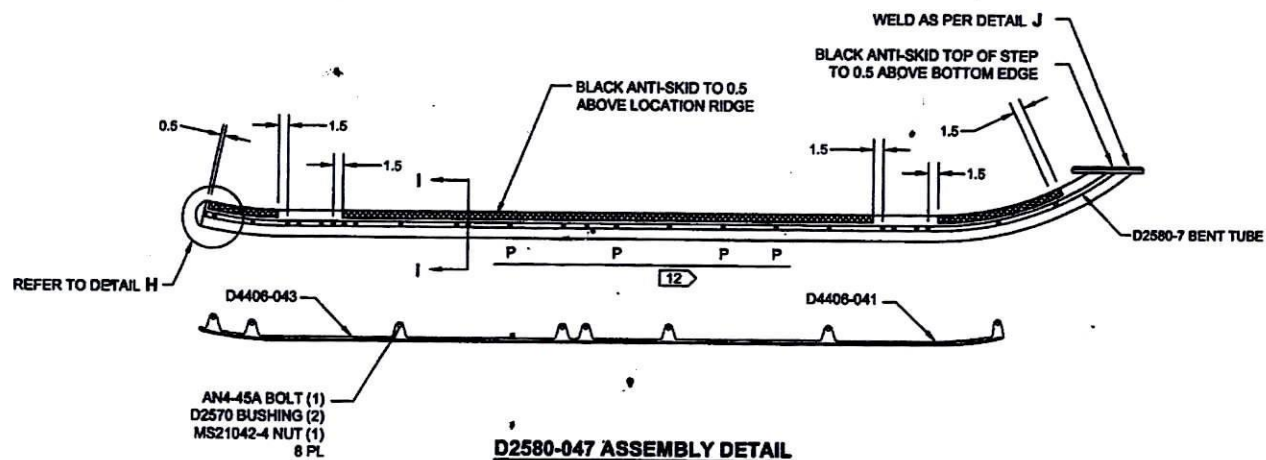


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

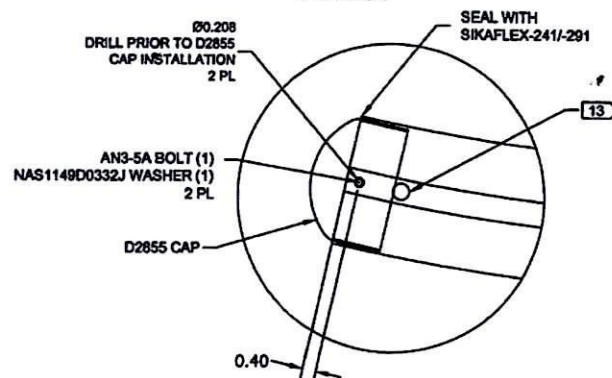
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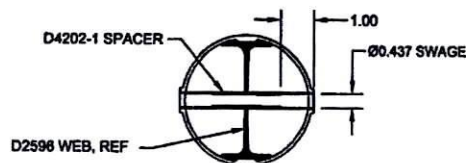
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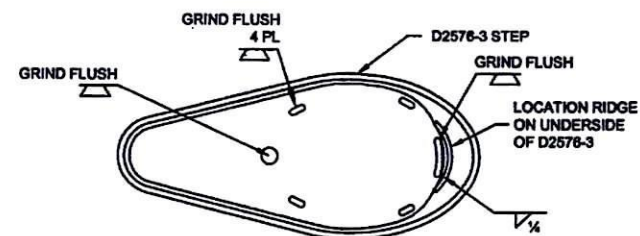


SECTION I-I
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

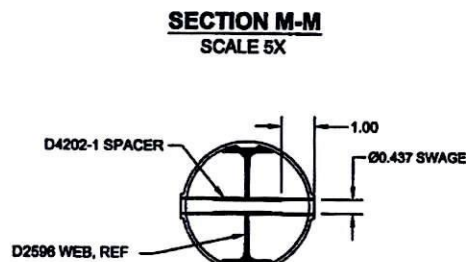
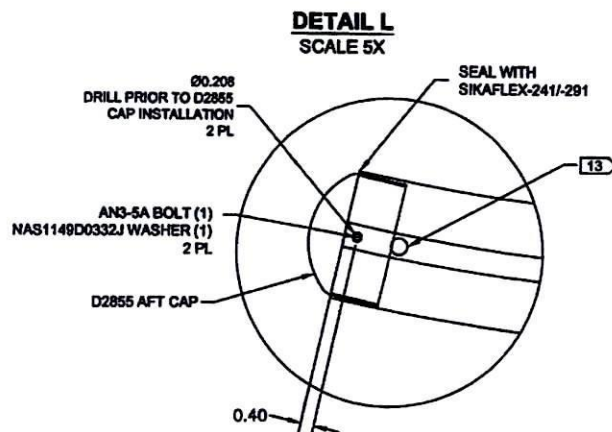
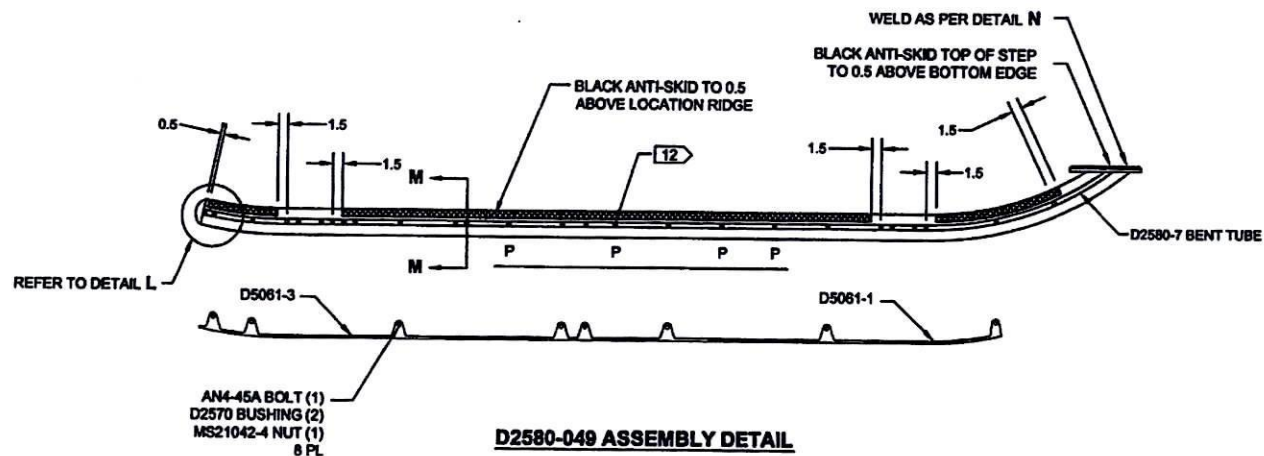
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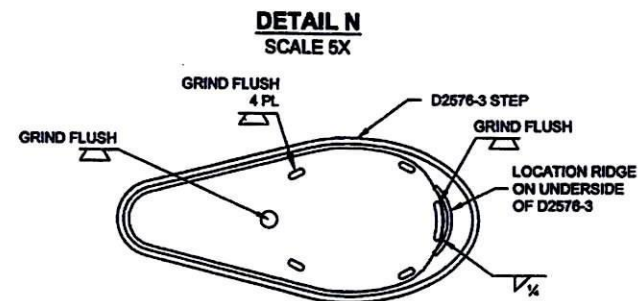
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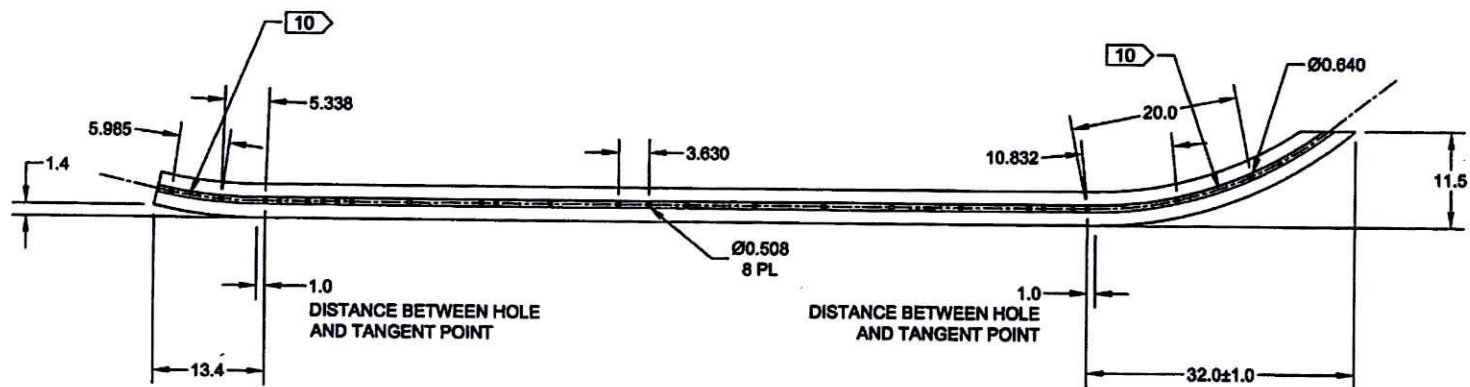


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
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2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



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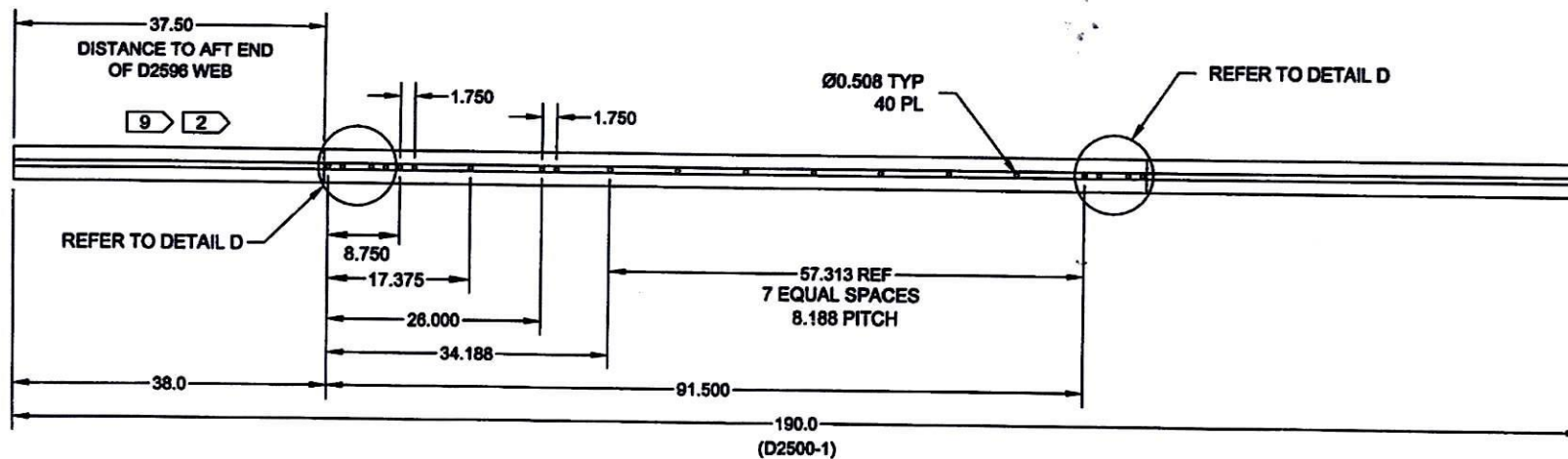
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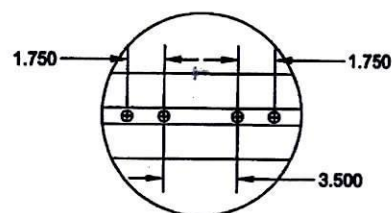
D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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2017 JUL 05

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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D2580-101 TUBE



DETAIL D
SCALE 5X

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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 9 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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